

MILITARY SPECIFICATION SHEET

FITTINGS, HYDRAULIC TUBE, FLARED, 37 DEGREE AND FLARELESS, STEEL;
 ELBOW, TUBE TO BOSS, 45 DEGREE, O-RING, 37 DEGREE FLARED

This specification is approved for use by all Departments and
 Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this
 specification sheet and the issue of the following specification listed in that
 issue of the Department of Defense Index of Specifications and Standards (DoDISS)
 specified in the solicitation: MIL-F-18866.

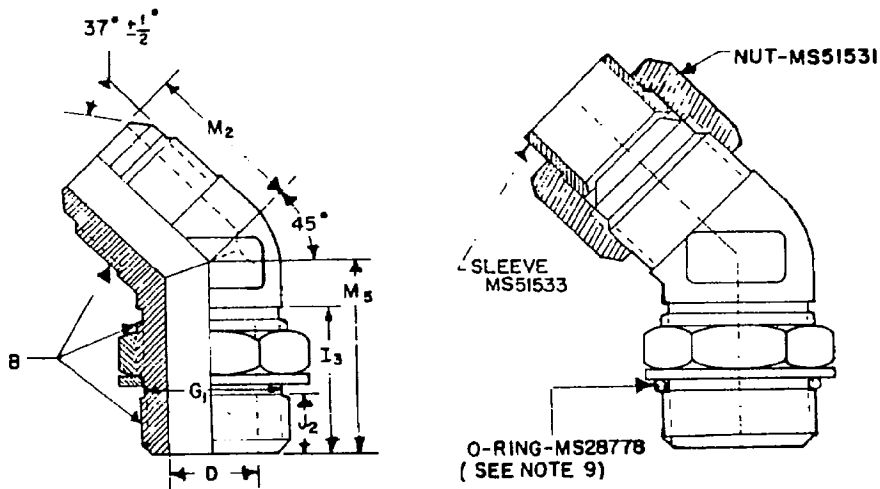


FIGURE 1. Elbow, Tube to Boss, 45 Degree, O-Ring, Flared.

Ⓑ Denotes change

TABLE I. Dimensional data.

DASH NUMBER		TUBE O.D. NOM	B	D		G ₁	I ₃	J ₂	H ₂	H ₅
BODY	#ASSY		STRAIGHT THREAD	DIAMETER		+.002 -.003	+/- .020	FULL THREAD +/- .005	+/- .030	+/- .030
				BASIC	TOLERANCE					
B2	A2	1/8	.3125-24 UNF-2A	.062	+/- .003	.250	.610	.234	.660	.880
B3	A3	3/16	.3750-24 UNF-2A	.125		.313	.610	.234	.660	.880
B4	A4	1/4	.4375-20 UNF-2A	.172		.364	.700	.281	.720	1.050
B5	A5	5/16	.5000-20 UNF-2A	.234		.427	.700	.281	.770	1.050
B6	A6	3/8	.5625-18 UNF-2A	.297	+/- .004	.482	.770	.312	.830	1.140
B8	A8	1/2	.7500-16 UNF-2A	.391		.660	.880	.344	.980	1.300
B10	A10	5/8	.8750-14 UNF-2A	.484		.773	1.020	.391	1.110	1.520
B12	A12	3/4	1.0625-12 UN-2A	.609		.945	1.160	.469	1.280	1.730
B14	A14	7/8	1.1875-12 UN-2A	.718	+ .007/- .005	1.070	1.160	.469	1.390	1.800
B16	A16	1	1.3125-12 UN-2A	.844		1.195	1.160	.469	1.470	1.860
B20	A20	1-1/4	1.6250-12 UN-2A	1.078		1.507	1.160	.469	1.590	1.910
B24	A24	1-1/2	1.8750-12 UN-2A	1.312		1.756	1.160	.469	1.780	1.910
B32	A32	2	2.5000-12 UN-2A	1.781	+ .010/- .005	2.381	1.160	.469	2.220	1.860

REQUIREMENTS:

1. MATERIAL: Steel, carbon in accordance with procurement specification.
Steel, corrosion-resisting in accordance with procurement specification.
2. PROTECTIVE COATING: Cadmium plated in accordance with procurement specification. Zinc plated in accordance with procurement specification. (B) Phosphate coated in accordance with procurement specification. (A phosphate coated locknut with cadmium or zinc plated body is acceptable.) Passivation treatment in accordance with procurement specification.
3. DIMENSIONS AND TOLERANCES: Dimensions and tolerances not shown shall be in accordance with the SAE standards for 37-degree flared fittings (SAE J514).
- (B) 4. THREADS: Threads shall be in accordance with Screw-Thread Standards for Federal Services. FED-STD-H28.
5. PART NUMBER: The MS part number consists of the MS number plus the dash number.
 - a. For body only, cadmium plated, use the MS number, plus the body dash number. Example: MS51528B2.
 - b. For complete assembly (with nut and sleeve), cadmium plated, use the MS number, plus the assembly dash number. Example: MS51528A2.

MS51528B

- c. For zinc coating add (Z) to the dash number. Example:
MS51528B2Z or MS51528A2Z.
 - d. For phosphate coating add (P) to the dash number. Example:
MS51528B2P or MS51528A2P.
 - e. For corrosion-resisting steel add (S) to the dash number.
Example: MS51528B2S or MS51528BA2S.
6. The illustration is for identification purposes only and is not intended to restrict designs or shapes not dimensioned.
- *7. Procure the O-ring separately and install immediately before installation of fitting.
8. After 17 January 1979 bodies will be used for production only and ~~SHALL NOT~~ be stocked for maintenance. Existing stock of bodies should be used until depleted.
9. In the event of a conflict between the text of this Military Specification Sheet and the reference cited herein, the text of this Military Specification Sheet shall take precedence.
10. Referenced Government (or non-Government) documents of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation form a part of this Military Specification Sheet to the extent specified herein.

CUSTODIAN:

- ⑧ AIR FORCE - 99
NAVY - OS

PREPARING ACTIVITY:
ARMY - AR

REVIEW ACTIVITIES:

- ⑧ AIR FORCE - 82
ARMY - ER, ME
DLA-CS

AGENT:
DLA-CS

USER ACTIVITIES:

ARMY - AT
NAVY - MC, YD

(PROJECT 4730-0912)